

Work Order ID 125522

Thursday, October 09, 2014 3:10:23 PM

125522

Page 1

Item ID: D350-591-214

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 10/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/9/2014 Req'd Qty: 1.00

1

Customer:

Reference: rework

Approvals: Process Plan: *MF*

Date: *14-10-09* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

DART		1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL: 1-813-632-5200 www.dartaerospace.com	
PATENT	N/A	QFC	CHG003
P/N	D350-591-214	STC	SH92-6
DESC	Heli-Access Step RH High	STC	SH967NE
LOT	B123251	STC	
MODEL	AS350/355	STC	
TC APPROVAL #09-09		MADE IN CANADA	
		02729-0	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3078	A
DSI 9472	A

310

0.00

310

HandFinish

Hand Finishing

Memo

0.00

D350-691-214 X 1 B123251 WAS PULLED FROM STOCK FOR SOME TESTING

CLEAN COMPLETELY AND DO TOUCH UPS IF NECESSARY

ENSURE ORIGINAL PICK KIT STAYS WITH SKIDTUBE

ADD D3338-1 x 1 B *127949*

*at chg 004 new.
per ECN - 14-670*

DAS

41

9-89

14-10-24

320

QC5- Inspect part completeness to step on W/O

0.00

320

QC

Quality Control

Memo

0.00

DAS

46

9-89

14-12-15 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D350-591-214

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH

Start Date: 10/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/9/2014 Req'd Qty: 1.00

1

Customer:

Reference: rework

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
330	Identify as per dwg & Stock Location: <u>G3A</u>	0.00				1			
330									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER				DAS				
	ENSURE PAPERWORK AND ORIGINAL KIT IS WITH STEP				06				
					3-89				
340	QC21- Final Inspection - Work Order Release	0.00							
340									
QC	Memo	0.00							
Quality Control									

JAN 22 2015

MCS 15-01-22

H15-1-22

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 125522

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Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step™ RH

Start Date: 10/9/2014

Required Date: 10/9/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.14Modified step 10KJ/EC
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D
 10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D350-591-214		Manufactured	No				Each	10.0000		1			
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D350-591-214

Heli-Access-Step™ RH

123251

Location

Loc Qty

Loc Code

FG039

10

113572

2

118399

1

120104

4

123251

3

CMF
15-1-20

D3338-1 x 1 127949

DAS

DAS

66

46

3-89

9-89

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